

Work Order ID 63342

Wednesday, October 27, 2010 4:00:09 PM

Page 1

Item ID: D412-711-101

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Bubble Window

Start Date: 10/27/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D412-711-101

A

100

0.00

DC

Document Control

Memo

Photocopy bluefiles and create labels
for PPP D412-711-101 Change 002

0.00

8/10/10/02

Defect BG 10-11-02

110

0.00

HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

Set up Machine as per folio FTA 077 and D711W program

0.00

1 10/10/28

120

0.00

HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

Cut Blanks to 36" by 39"

0.00

1 10/10/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:


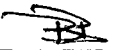




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Thermoform	THERMOFORMING MACHINE	0.00				1			 10/10/20
Thermoforming Machine	Memo Thermoform as per Dwg. D412-711-101 using DT 9640 and Folio FTA 077 Dwg. Rev. _____ Folio Rev. _____	0.00							
140  QC	QC2- Inspect parts off machine FAI/FAIB	0.00				1			 10/10/20
Quality Control	Memo 1) Check Surface finish for undesired marks, voids, dimples etc. 2) Check depth of bubble to ensure conformity to drawing tolerances.	0.00							
150  QC	QC8- Inspect parts - second check	0.00							 10/10/29
Quality Control	Memo	0.00							

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00



HandThermo

HAND FINISHING THERMOFORMING

Memo

0.00

Hand Finishing Thermoforming

1) Trim off excess flange material
2) Buff out any light scratches or
3) Etch part number and batch number

(IX)

JBB 10/11/01

170

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

1) Visually inspect for clarity, and proper formation.

(IX)

JBB 10/11/01

180

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

1) Visually inspect for clarity, and proper formation.

S 10/11/01

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

185

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location 80

0.00



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CR 10/11/03

MF

10-11-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 63342



Parent Item: D412-711-101



Parent Item Name: Replacement Bubble Window

Start Date: 10/27/2010


Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-02-01 JLM
Manufacture in-house 10/06/28 DL

IPP Rev. B.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.236 		Purchased	No				sf	73.0000	16	16			

Plexiglass G .236"

Location

Loc Qty

Loc Code

therm

73

113571

17

115096

16

115590

40

BB
10/10/28

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 63342
Description: BUBBLE WINDOW	Part Number: D412-711-101
Inspection Dwg: D412 711 101 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JB	Date: 10/10/28
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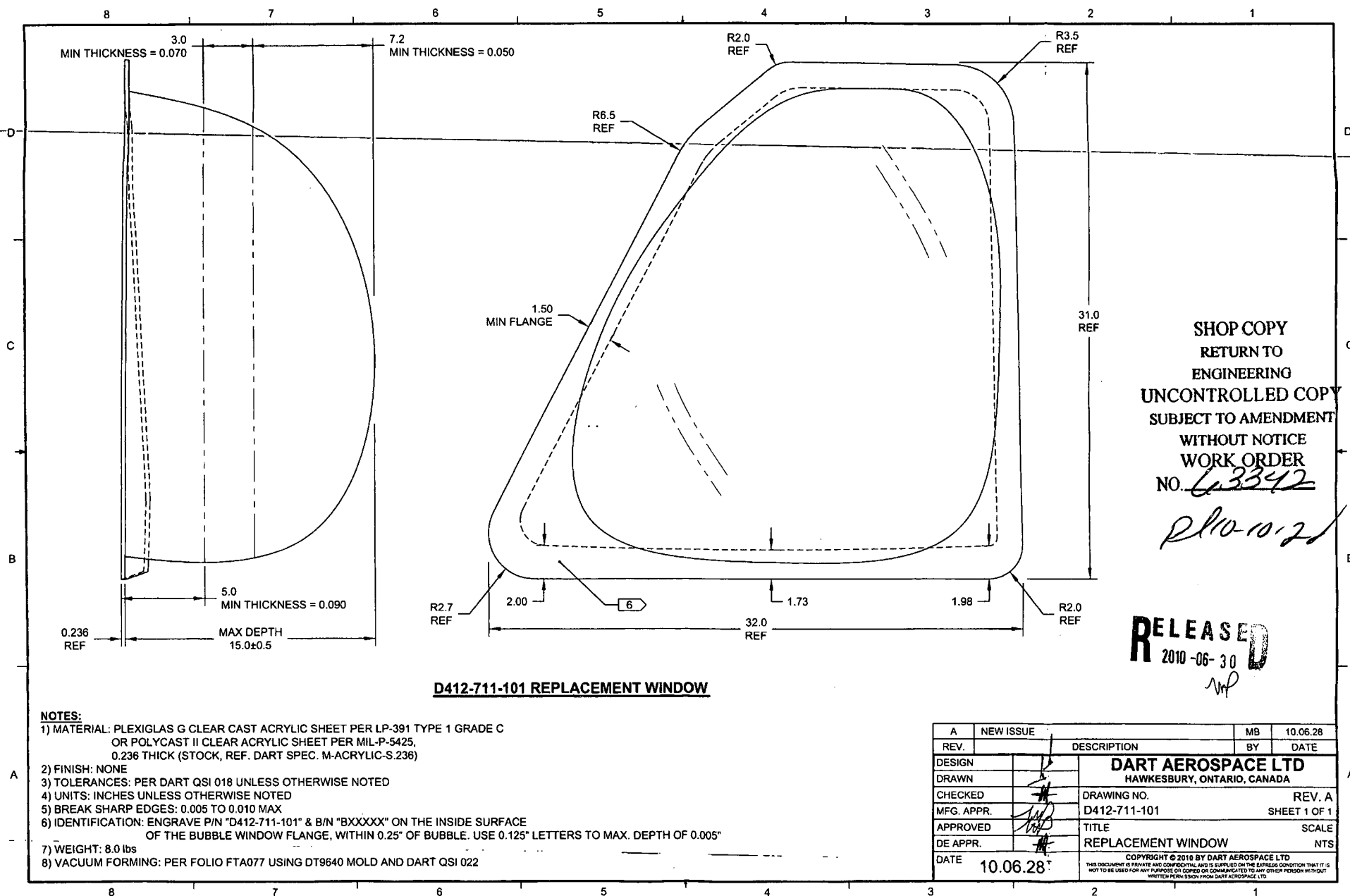
TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.0	REF	32.25	✓			
31.0	REF	31.125	✓			
1.50	M.I.D	1.5	✓			
1.73		1.875	✓			
.070	±0.015	.096	✓			
.090		.090	✓			
.050		.076	✓			
15	±0.5	14.9	✓			

Measured by: JB	Date: 10/10/29
Audited by: [Signature]	Date: 10/10/29
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14



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